

Date: Tuesday, 4/24/2007 3:15:52 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: EYEBALL ADAPTER
Job Number	: 32036		
Estimate Number	: 12246		
P.O. Number	: N/A	Part Number	: D3480041
This Issue	: 4/24/2007 S.O. No. : N/A	Drawing Number	: D3480 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28528	Material	: N/A
Written By	:	Due Date	: 5/8/2007
Checked & Approved By	: <u>07.04.25</u>	Qty:	4 Um: Each
Comment	: est rev. A 06.02.07 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34805	EYEBALL ADAPTER FLANGE
-----	--------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-5	Flange	B32014

2.0	D34803	tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3480-3	Tube	B32013

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot weld as per dwg D3480

2-Cut tube flush as per dwg D3480

3-Deburr

4.0 QC11 VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:15:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 32036

Part Number: D3480041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

812 07/05/02

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stook
Location: _____

07/05/02 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/03

(4)

Job Completion



U 07/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

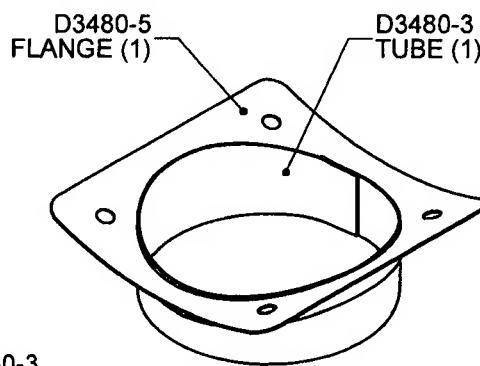
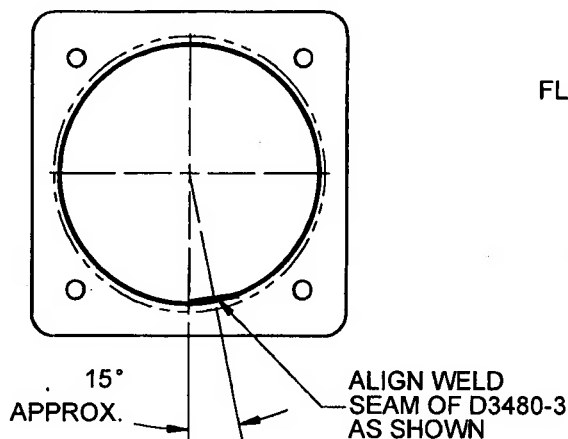
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

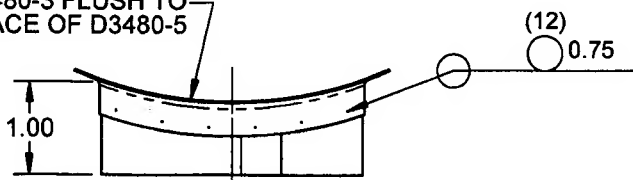
NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3480	REV. B SHEET 1 OF 6
DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2
A	06.02.06	NEW ISSUE	
B	06.08.29	D3480-3 0.50 was 0.40/D3480-3F 8.930 was 9.330	



SPOT WELD PARTS, THEN
CUT D3480-3 FLUSH TO
SURFACE OF D3480-5



D3480-041 EYEBALL INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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06.09.19 *H*

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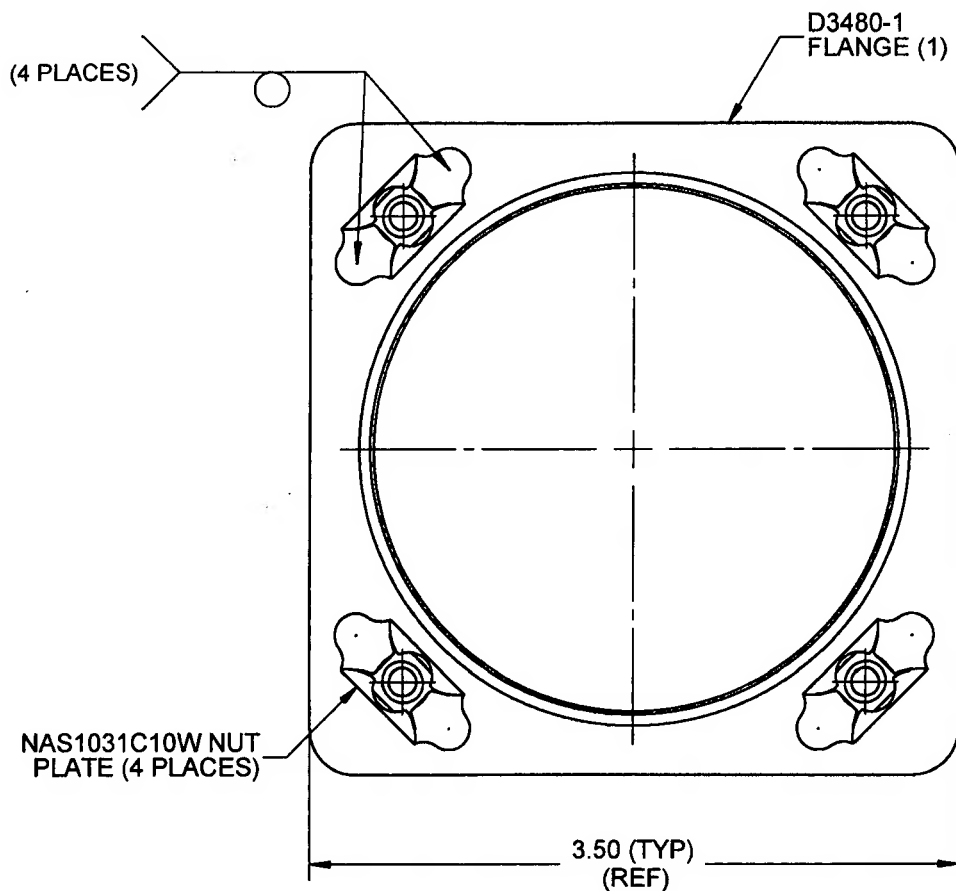
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NO. 32036



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DATE 06.08.29		TITLE EYEBALL ADAPTER SCALE 1:1	

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D3480-043 EYEBALL ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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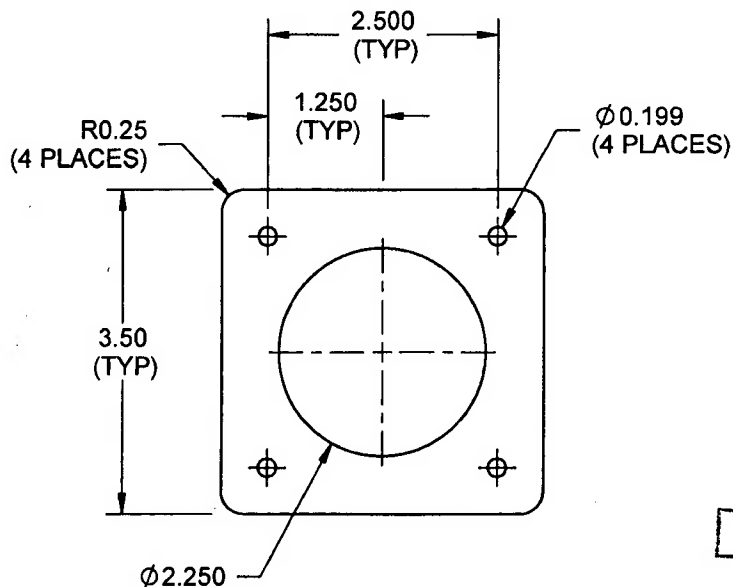
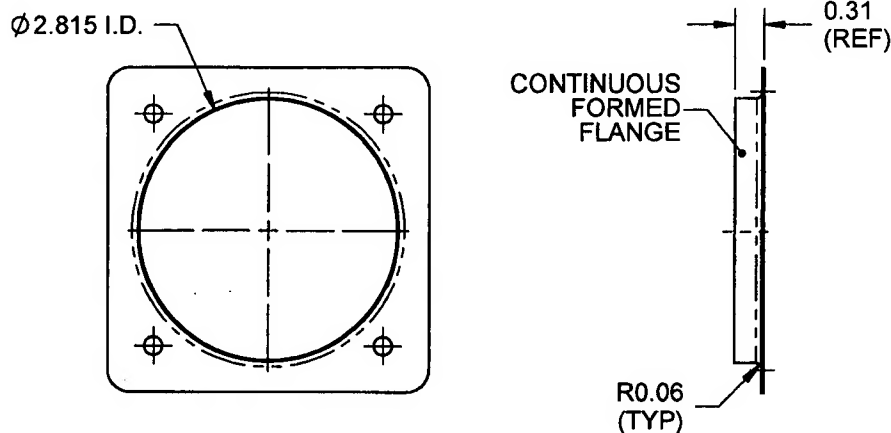
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2

**RELEASED**06.09.19 *H***D3480-1F FLAT PATTERN****D3480-1 FLANGE**
(MAKE FROM D3480-1F)**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

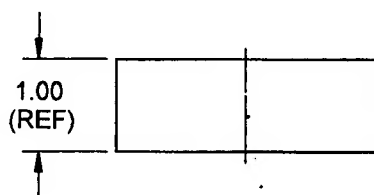
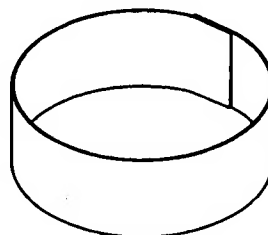
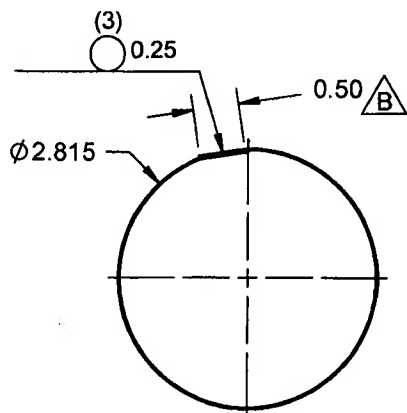
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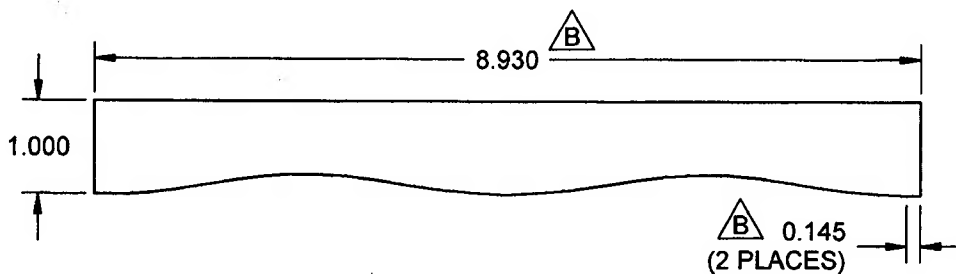
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2



RELEASED

06.09.19 *[Signature]*

D3480-3 TUBE



D3480-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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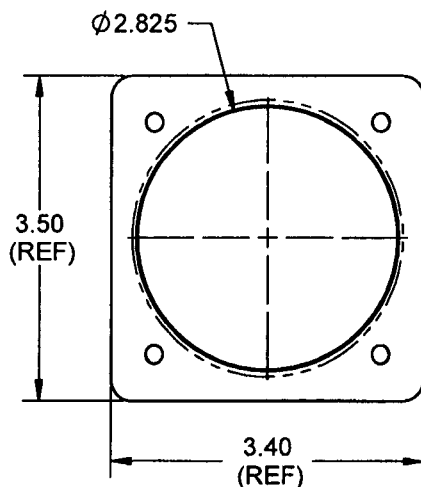
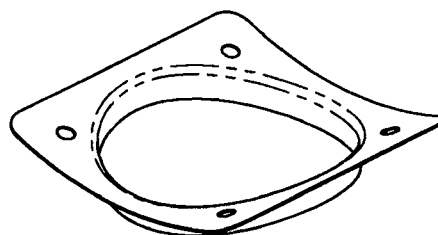
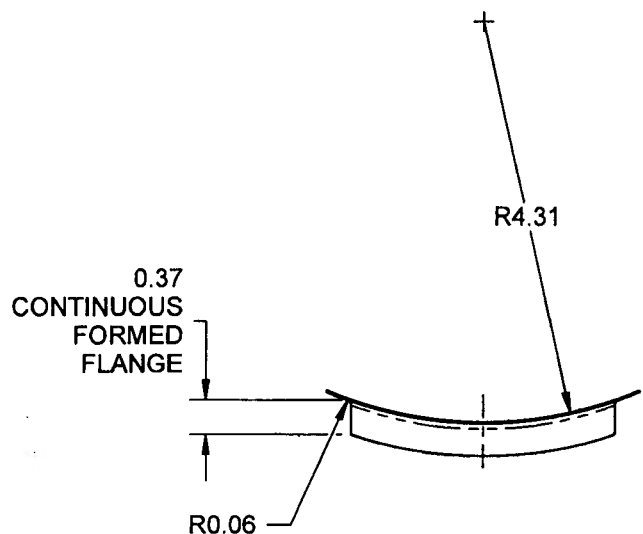
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SCALE 1:2

**RELEASED**06.09.19 *[Signature]***D3480-5 EYEBALL ADAPTER FLANGE****NOTES:**

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

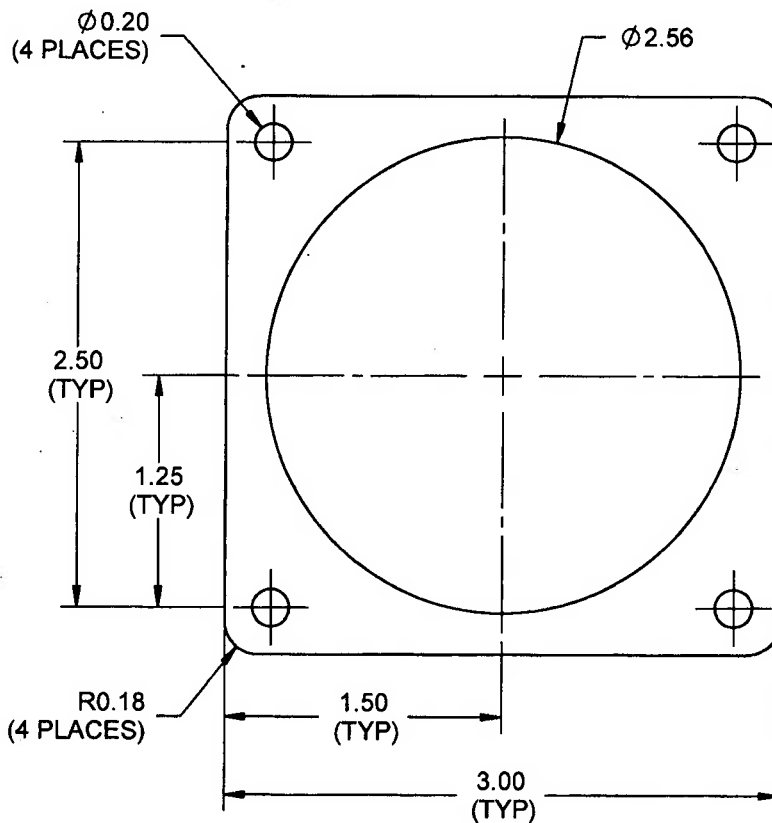
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DATE 06.08.29		TITLE EYEBALL ADAPTER	SHEET 6 OF 6 SCALE 1:1



RELEASED

06.09.19 *PH***D3480-7 GASKET****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO: 11

EMPLOYEE: Dea Stea

PART NUMBER: P 348 Q41

JOB NUMBER: B 32036

MATERIAL TYPE: 304 S

MATERIAL THICKNESS: 24 G

GROUP SPECIFICATION: 2

Group 1: Aluminum & magnesium

Group 2: Iron, nickel, cobalt

Group 3: Titanium

TEST RESULTS

PASS FAIL

VISUAL:

/ / / /

PENETRATION:

/ / / /

PULL STRENGTH:

/ / / /

PSI Reading: _____

The individual named above has been trained and is qualified in accordance with standard AMS-W-6858A. and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/05/02

QUALIFIER: SG